

ABSTRACT OF THE DISCLOSURE

This invention provides a laser welding method capable of supplying a filler wire to a welding object portion in a stabilized condition so as to stabilize welding quality. More specifically, the filler wire is supplied to the welding object portion while the laser beam is projected to the welding object portion. At this time, the filler wire is supplied obliquely from forward or backward in the welding advance direction such that the angle between the supplying direction and beam axis  $L$  of the laser beam is less than  $45^\circ$ .